

# Work Order ID 65706

Monday, January 24, 2011 8:59:24 AM



~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Item Name: Angle, Aft, LH

Stop



Start Date: 1/24/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 3.00

Customer:



Reference:

*Jan 11.01.24*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	<i>BU/R c pnet</i>								

*Jan 11.01.24*

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.625" long

*SL 11/01/25*

*(3)*

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: *201*

Folio Rev: *AA*

*ML 11.1.26*

*3*

*1*

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4038-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: prelim, new program Date: 11-01-26

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>65706</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11-1-26</u>	<u>110</u>	<u>- Center drill too deep.</u> <u>- Operator error, forgot</u> <u>to reduce the depth of the bit.</u> <u>2C.L.A.</u>	<u>[Signature]</u>	<u>Scrap + replace</u>	<u>[Signature]</u> <u>11-1-26</u>	<u>M.A</u> <u>11/01/27</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>11/01/26</u>

NOTE: Date & initial all entries

**Work Order ID 65706**

Monday, January 24, 2011 8:59:24 AM



Page 2

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, LH

Start Date: 1/24/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00				<u>3</u>	<u>1</u>		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				<u>3</u>	<u>0</u>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>3</u>	<u>0</u>		

S.A 11.1.24

S.A 11/01/27

3 BL 11-01-27

**Work Order ID 65706**

Monday, January 24, 2011 8:59:24 AM

Page 3

Item ID: D4038-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle, Aft, LH

Start Date: 1/24/2011 Start Qty: 3.00

Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1/24/11 (3)

160

Identify as per dwg & Stock Location: 112

0.00



Packaging

Memo

0.00

Packaging

1/24/11 (3)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1/31/11  
1/31/11**POSITIVE RECALL**EFFECTIVE 1/24/11 AUTH uRELEASED 1/24/11 DATE 1/26/11FOR ENH-11-500  
AND STRAPPED END

# Picklist Print

Monday, January 24, 2011 8:59:19 AM

Page 1

Work Order ID: 65706



Parent Item: D4038-3



Parent Item Name: Angle, Aft, LH

Start Date: 1/24/2011

Required Date: 1/26/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	16.9131	0.7	2.210526			
6061T6 ANGLE 4.00 x 4.00 x .250													



22 11/01/25

Location	Loc Qty	Loc Code
MAT	16.7447	
114507	16.7447	
MAT06	0.1684	
113391	0.1684	

2.22

DART AEROSPACE LTD		Work Order: 65706
Description: ANGLE, PCT, 1H		Part Number: 4038-3
Inspection Dwg:	Rev: PC1	Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

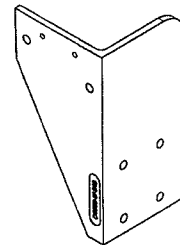
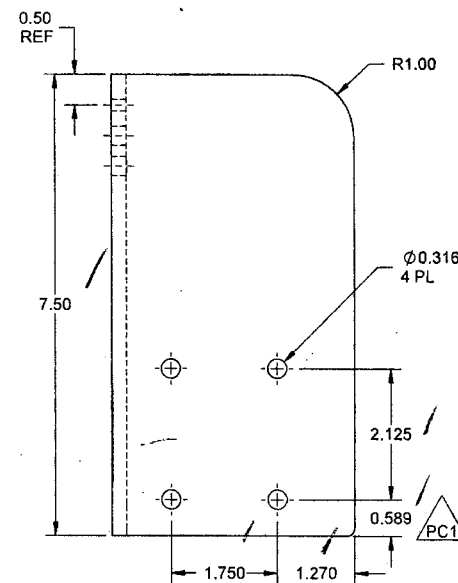
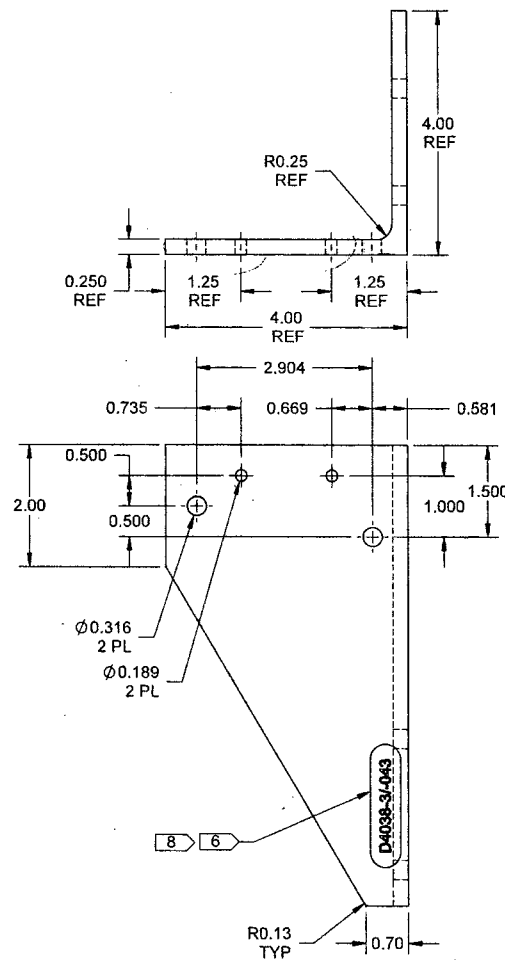
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00 ref	+/- .030	3.998			RP-02	all.
R.25 ref	+/- .030	.250				
.250 ref	+/- .010	.240				
1.25 ref	+/- .030	1.250				
1.25 ref	+/- .030	1.250				
4.00 ref	+/- .030	3.997				
2.904	+/- .010	2.904				
.735	+/- .010	.735				
.669	+/- .010	.669				
.581	+/- .010	.579				
.500	+/- .010	.500				
1.500	+/- .010	1.500				
2.00	+/- .030	2.000				
1.000	+/- .010	1.000				
.500	+/- .010	.500				
.316	+ .006 - .001	.316				
.189	+ .005 - .001	.189				
2.13 typ	+/- .030	.125				
.70	+/- .030	.70				
Continued on next page.						

Measured by: <i>[Signature]</i>	Audited by: H.A	Prototype Approval:
Date: 11-1-26	Date: 11/01/27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	






# NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.19 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

**D4038-3 ANGLE, AFT, LH**

**PRELIMINARY ISSUE**

11.01.20

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PC1
MFG. APPR.		<b>D4038</b>	SHEET 5 OF 14
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	<b>11.01.20</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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**Linda Lacelle**

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**From:** Marc Bellavance <mbellavance@dartaero.com>  
**Sent:** January 28, 2011 10:52 AM  
**To:** 'David Shepherd'; 'Harvey Siemens'; Lacelle, Linda  
**Subject:** RE: D130-701-043 Basket

Thanks a bunch guys!

Linda,

Let me know when the W/O's are ready for sign offs.

The D4038 dwg will be released when we get the paperwork back from David early next week.

**Marc Bellavance**  
**Technical/Shop Support**

***DART*** aerospace Ltd.

Tel: 613-632-5200 Ext. 243

Cel: 613-676-0992

Fax: 613-632-9311

E-mail: [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)

Web: [www.dartaero.com](http://www.dartaero.com)

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**From:** David Shepherd [mailto:[dshepherd@dartaero.com](mailto:dshepherd@dartaero.com)]  
**Sent:** January 28, 2011 10:46 AM  
**To:** 'Marc Bellavance'; 'Harvey Siemens'  
**Subject:** RE: D130-701-043 Basket

Yup ... Let's go for it.

David

**From:** Marc Bellavance [mailto:[mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)]  
**Sent:** Friday, January 28, 2011 8:36 AM  
**To:** 'Harvey Siemens'; 'David Shepherd'  
**Subject:** RE: D130-701-043 Basket

Good news indeed! ☺

So I can print this chain of emails and give the "OK to ship" to Linda then?

**Marc Bellavance**

Technical/Shop Support

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**From:** Harvey Siemens [<mailto:hsiemens@dartaero.com>]

**Sent:** January 28, 2011 10:38 AM

**To:** 'Marc Bellavance'; 'David Shepherd'

**Subject:** RE: D130-701-043 Basket

Good news Boss

I was just over at the Hangar checking the last 130 that is here. There is a comfortable 0.375" between the aft tank support and the cowl. So our customer shouldn't have any trouble getting his cowl to fit around the lowered beam.

Regards,

*Harvey Siemens*

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: [hsiemens@dartaero.com](mailto:hsiemens@dartaero.com)

W: [www.dartaero.com](http://www.dartaero.com)

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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**From:** Marc Bellavance [<mailto:mbellavance@dartaero.com>]

**Sent:** January-28-11 7:34 AM

**To:** 'Harvey Siemens'; 'David Shepherd'

**Subject:** RE: D130-701-043 Basket

Thanks Harvey, much appreciated.

Marc Bellavance

Technical/Shop Support

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**From:** Harvey Siemens [<mailto:hsiemens@dartaero.com>]

**Sent:** January 28, 2011 9:07 AM

**To:** 'Marc Bellavance'; 'David Shepherd'

**Subject:** RE: D130-701-043 Basket

I will attempt to verify that there is enough room in the cowl, first thing this morning and let you know Marc.

Regards,

*Harvey Siemens*

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

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**From:** Marc Bellavance [<mailto:mbellavance@dartaero.com>]

**Sent:** January-28-11 6:27 AM

**To:** 'David Shepherd'

**Cc:** 'Harvey Siemens'

**Subject:** RE: D130-701-043 Basket

I do not have the means to verify this and honestly thought this was taken into account when I was asked to lower the holes...

Harvey,

Does Eagle have an EC130 available to verify this? Or perhaps with the help of pictures?

The IIN shows a cutout pattern. Maybe all there is to it is increase the cutout by whatever is required?

Or... I can go back to the our unhappy installer and ask...

Marc Bellavance

Technical/Shop Support

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**From:** David Shepherd [mailto:[dshepherd@dartaero.com](mailto:dshepherd@dartaero.com)]

**Sent:** January 28, 2011 12:11 AM

**To:** 'Marc Bellavance'

**Cc:** Harvey Siemens

**Subject:** RE: D130-701-043 Basket

Marc,

I signed D4038 Rev C tonight. Just occurred to me ... Are we 100% sure there is enough room in the cowling to drop the beam by 0.125"?

David

**From:** Marc Bellavance [mailto:[mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)]

**Sent:** Thursday, January 27, 2011 9:15 AM

**To:** Shepherd, David

**Subject:** FW: D130-701-043 Basket

**Importance:** High

Customers are enquiring about shipping...

Thanks,

Marc Bellavance

Technical/Shop Support

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**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** January 26, 2011 3:59 PM  
**To:** Shepherd, David  
**Cc:** Petsche, Mike  
**Subject:** D130-701-043 Basket  
**Importance:** High

Hi David,

As discussed over the phone today, here is the drawing change with ADR and MDL.

Thanks!

**Marc Bellavance**  
**Technical/Shop Support**

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**From:** Harvey Siemens [mailto:hsiemens@dartaero.com]  
**Sent:** January 26, 2011 3:08 PM  
**To:** 'Marc Bellavance'  
**Cc:** 'Menard, Jean-Luc'; 'David Shepherd'  
**Subject:** RE: D4038-3/-4 (ref. D130-701 Basket)

Marc

Sounds like we should be ok with that edge distance. I'll leave it to David to make the final call.

Regards,

*Harvey Siemens*

Mechanical Designer  
DART Aerospace Ltd.

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**From:** Marc Bellavance [mailto:mbellavance@dartaero.com]  
**Sent:** January-25-11 9:43 AM  
**To:** Siemens, Harvey  
**Cc:** Menard, Jean-Luc  
**Subject:** D4038-3/-4 (ref. D130-701 Basket)  
**Importance:** High

Harvey,

The revised dimension for the bracket angle is 0.589 which leaves a little more than 1.5 ED.  
Hole size is  $0.316 \times 1.5 = 0.474$  (0.589 on bracket, was 0.714).  
Generally, 1.5 ED is OK but in your opinion, is this good enough or do you recommend increasing to 2X ED?

**Marc Bellavance**  
**Technical/Shop Support**

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E-mail: [mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)

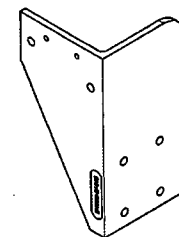
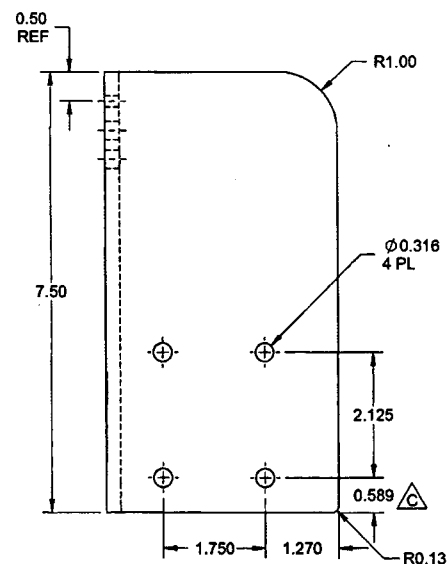
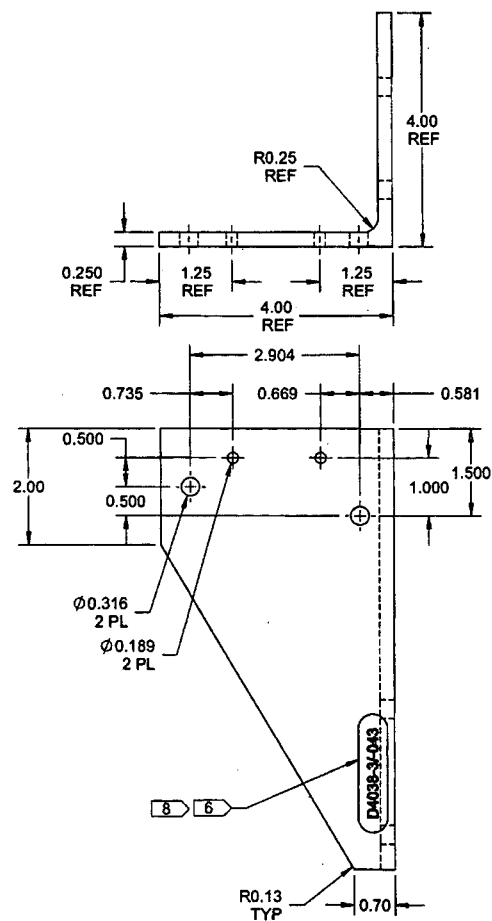
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65706

RELEASED  
2011-01-31

# NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.19 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

**D4038-3 ANGLE, AFT, LH**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D4038</b>	SHEET 5 OF 14
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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